

Work Order ID 144453

April 18, 2016 2:06:02 PM

144453

Need ASAP
need for SO ship 25th
to April 25th
Page 1

Item ID: D3319-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Forward Wearplate
Start Date: 4/25/2016 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 5/5/2016 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: SH Date: 20160418 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3319	C

100 FLOW WATER JET 0.07

100

Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3319
Dwg Rev: 6
Prog Rev: 6
2-Deburr if necessary

1.80

(24) _____ 02/04/19

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC
Quality Control

Memo

0.20

(24) _____ 02/6-4/17

120 QC8- Inspect parts - second check 0.00

120

QC
Quality Control

Memo

0.40

(24) _____

DAS
38
3.00
APR 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Forward Wearplate
 Start Date: 4/25/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 20.00 ***20*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	NC BRAKE	0.07							
140					DAS	24			APR 21 2016
Brake NC	Memo	1.00			30				
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <i>C</i> 2- Form flat on press using DT8776 block				9-89				
150	QC5- Inspect part completeness to step on W/O	0.00							
150						(24)			DAS
QC	Memo	0.40							38
Quality Control									APR 21 2016
160	Weld per dwg A/R Hardcoat steel Batch: <i>13146</i>	0.00							
160	Large Fab					24			16-04-26
Large Fab	Memo	3.80							<i>JAL</i>
Large Fab	1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: <i>C</i>								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00				(24)			DAS 38 9-89
Quality Control									APR 27 2016
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.40				(24)			DAS 38 9-89
Quality Control									APR 27 2016
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190	<i>M 1307 1/6</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>2:30</i> OVEN TEMPERATURE: <i>325</i> FINISH TIME: <i>3:00</i>								<i>24</i> <i>16-04-27</i> <i>DAS 34 9-89</i>

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.20							DAS 38 9-88
Quality Control									APR 28 2016
210	Identify as per dwg & Stock Location: _____	0.00							
210	Packaging								
Packaging	Memo	0.20							
Packaging	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-1, B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock Location: <u>5H 603</u>								24 DAS 38 9-88 APR 28 2016
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	2.00							
Quality Control									MLJ APR 28 2016

MLJ APR 28 2016

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

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Work Order ID: 144453

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Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 4/25/2016

Required Date: 5/5/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B05.10.14 Added step 9, dwg rev B KJ/EC
IPP Rev: C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	92.7042	0.628	13.22105			

M1010S18GA

1010/1025 SHEET .048

Dec 16 / 19

Location

Loc Qty

Loc Code

MAT019

92.704152

124428

3

m130454

0.3542

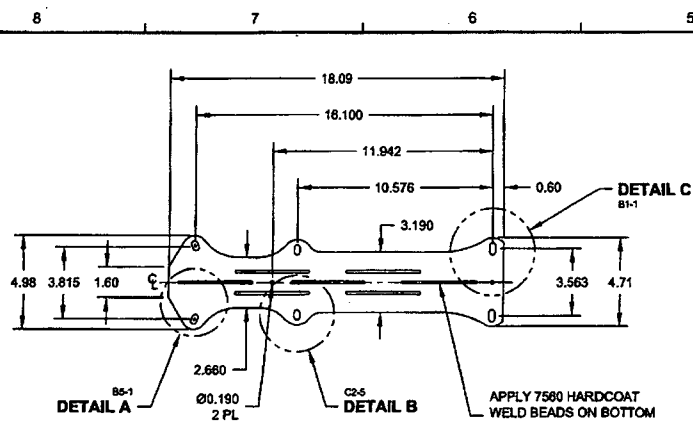
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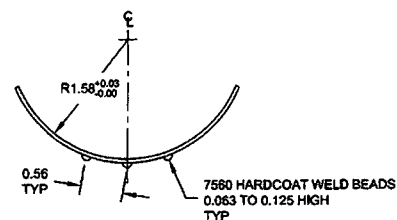
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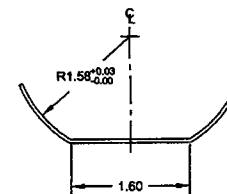
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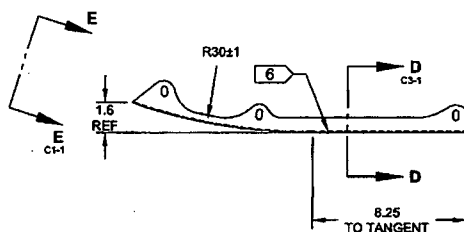
D3319-1F FLAT PATTERN



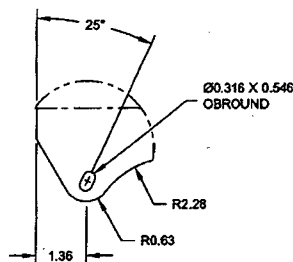
SECTION D-D
SCALE 4X



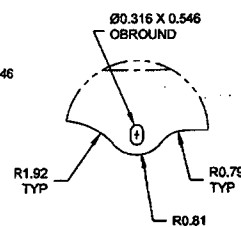
SECTION E-E
SCALE 4X



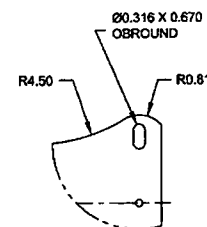
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

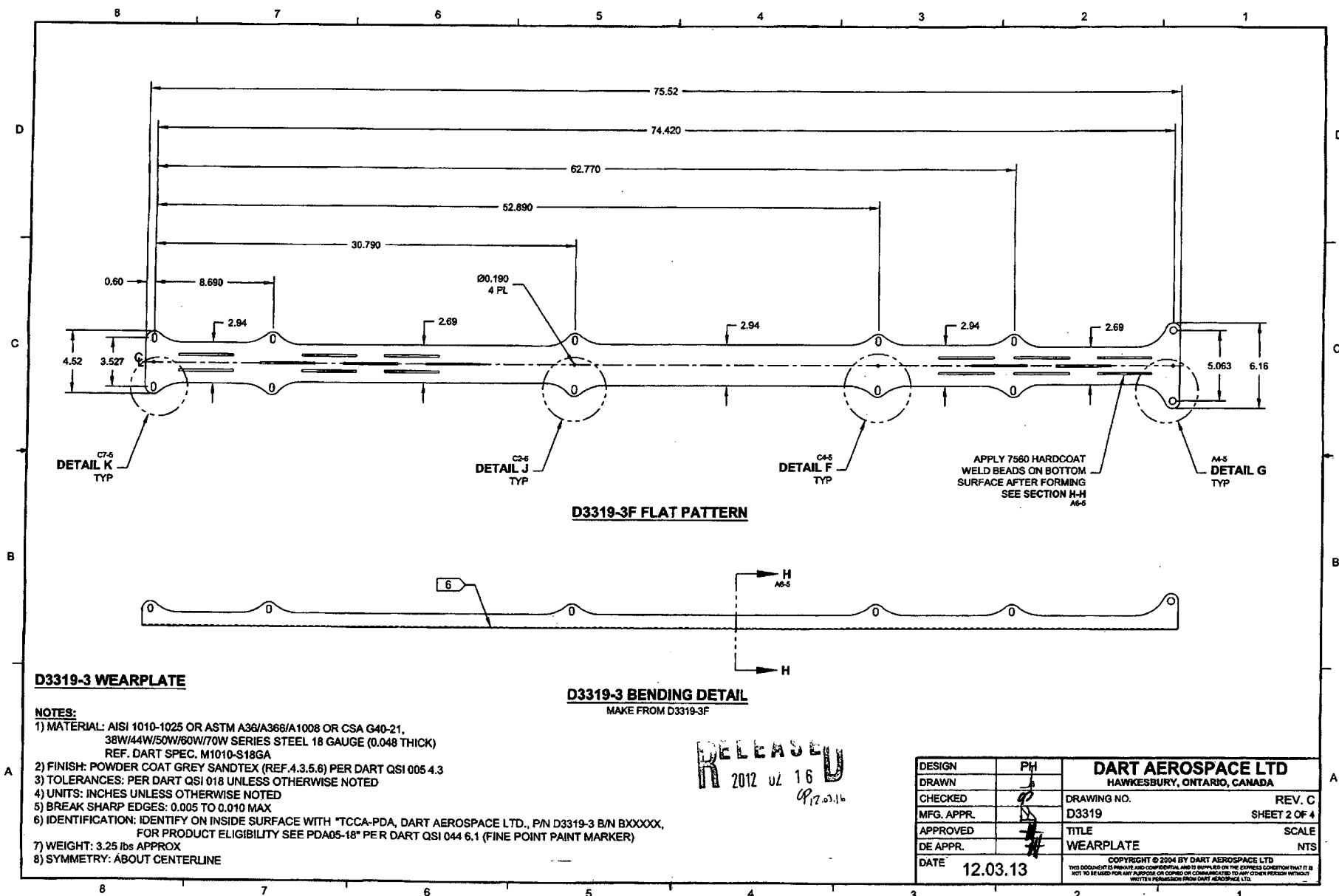
D3319-1 WEARPLATE

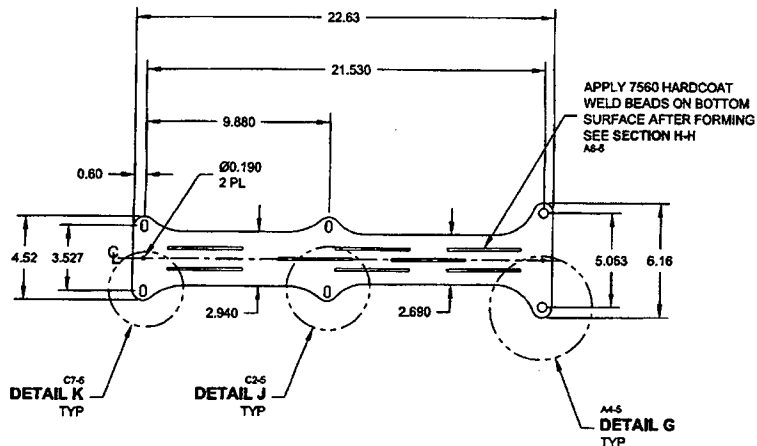
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

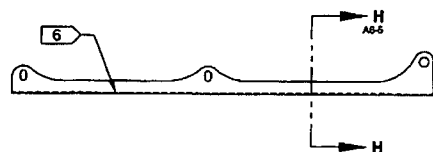
RELEASED
2012-03-16
PER ECN 12-546 12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/-5/-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

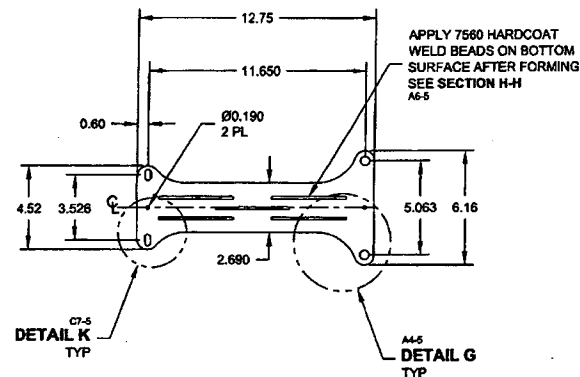




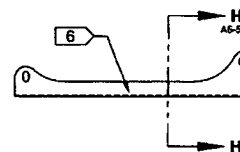
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

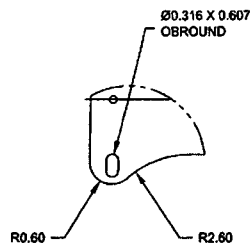
D3319-5/-7 WEARPLATE

NOTES:

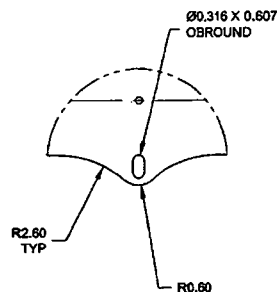
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N 8XXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

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2012-02-16
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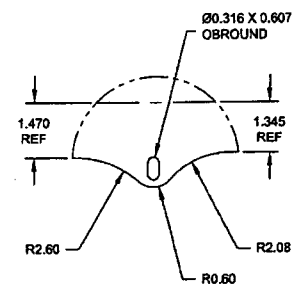
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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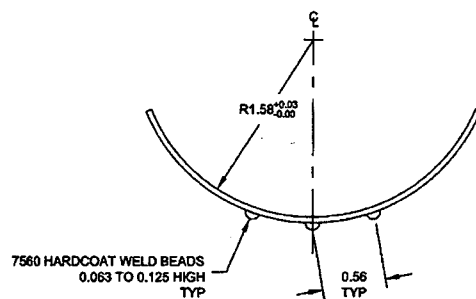
DETAIL K
SCALE 2X
B8-2
C4-3
C8-3



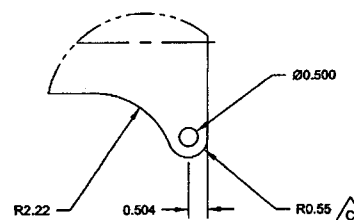
DETAIL F
SCALE 2X
B8-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3

RELEASED
2012-02-16
R2.03.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3319	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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DART AEROSPACE LTD		Work Order:	144453
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.98	✓			
1.600	+/-0.010	1.6	✓			
2.660	+/-0.010	2.67	✓			
3.190	+/-0.010	3.197	✓			
3.563	+/-0.010	3.56	✓			
4.71	+/-0.030	4.71	✓			
0.60	+/-0.030	0.6	✓			
10.576	+/-0.010	10.576	✓			
11.942	+/-0.010	11.942	✓			
18.09	+/-0.030	18.09	✓			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	0.317 x 0.547	✓			
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	0.317 x 0.672	✓			
Ø0.190	+0.005/-0.001	0.195	✓			
3.815	+/-0.010	3.815	✓			
16.100	+/-0.010	16.1	✓			

Measured by:	EL	Audited by:	DAS 38	Preliminary Approval:	
Date:	16-4-19	Date:	APR 20 2016	Date:	

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	